

Work Order ID 50253

July 14, 2009 10:43:25 AM



Page 1

Item ID: D3183-042

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00



Customer:

Reference:

09-07-16

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.500" x 2.000") 4.300" long

mmf 09/08/11

6

*PTO
Last Page*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3183-2 as per Folio FA320 and Dwg D3183 Identify as D3183-

2-12-Debur 13-Scribe batch number

mmf 09/08/11 / SL 09/08/13

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo


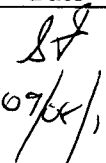
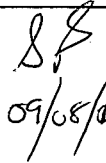

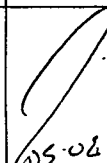

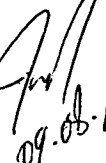

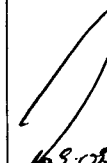
0.00

Quality Control

mmf 09/08/12 / SL 09/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3183-042 PAR #: NA Fault Category: Material NCR: ☒ Yes No DQA: 10 Date: 09.08.26
Scrap 1 Scrap QA: N/C Closed: 10 Date: 09.08.27

NCR: <u>50253</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/19	110	One part pop out of the Jig on first operation the feed too fast when		Scrap no replace cant remachine the part in the jig. Qty (1)	 09/08/19	 09/08/09	 09.08.19	 09.08.19
		machine back angle R-C: program		re-adjust feed in program.	 09.08.19	J-F-S 09/08/19	 09.08.19	 09.08.19

NOTE: Date & initial all entries

Work Order ID 50253

July 14, 2009 10:43:25 AM



Page 2

Item ID: D3183-042

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2809/08/19

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3183-041 as per Dwg D3183.

2809/08/20 5

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 809/08/20

45

nt
10:43:24 AM

Page 1

Order ID: 50253



Parent Item: D3183-042RevC1



Parent Item Name: Bracket Assembly

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3121-21RevE		Manufactured	No			140	Each	74.0000	10.0000			
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Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 74

46032 17

46739 17

50096 40

D3183-045RevC1		Manufactured	No			100	Each	19.0000	10.0000			
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Bearing Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 19

46393 3

47756 16

M174B2.000X01.500		Purchased	No			140	f	2.9600	2.4121			
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17-4 SS Bar 2.00 x 1.500

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 2.96

14773 1.29

19478 1.67

17-4 SS Bar 2.25x1.50 11899

mm
09/08/20

2.2575

EP09/08/20

10

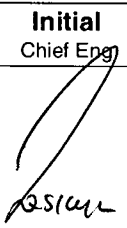
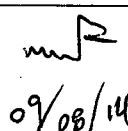
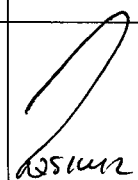
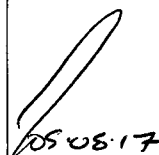

EP09/08/20

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/13	110	2 parts scrapped, popped out of jig and parts were damaged by end-mill while flying out R.C. Process		Scrap + replace Qty 2 M 111899	JL 09/08/13	 09/08/14		
								

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50253
Description: Bracket		Part Number:	D3183-2
Inspection Dwg: D3183	Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.162	+/-0.010	.168				
R0.25	+/-0.030	R.250				
3.105	+/-0.010	3.106				
2.075	+/-0.010	2.075				
0.786	+/-0.010	.777				
0.162	+/-0.010	.163				
100°	+/-0.05°	100°				
2.799	+/-0.010	2.800				
Ø0.392	+0.002/-0.000	.393				
1.90	+/-0.030	1.889				
0.218	+/-0.010	.212				
0.500	+/-0.010	.500				
3.881	+/-0.010	3.886				
4.17	+/-0.030	4.17				
Ø0.201 x 100 deep	+/-0.010	.199 x .201				
0.182	+/-0.010	.182				
0.070	+/-0.010	.070				
0.100	+/-0.010	.104				
4.8°	+/-0.05°	4.8°				
0.381	+/-0.010	.391				
0.200	+/-0.010	.200				
0.435	+/-0.010	.433				
0.615	+/-0.010	.613				
0.032	+/-0.010	.030				

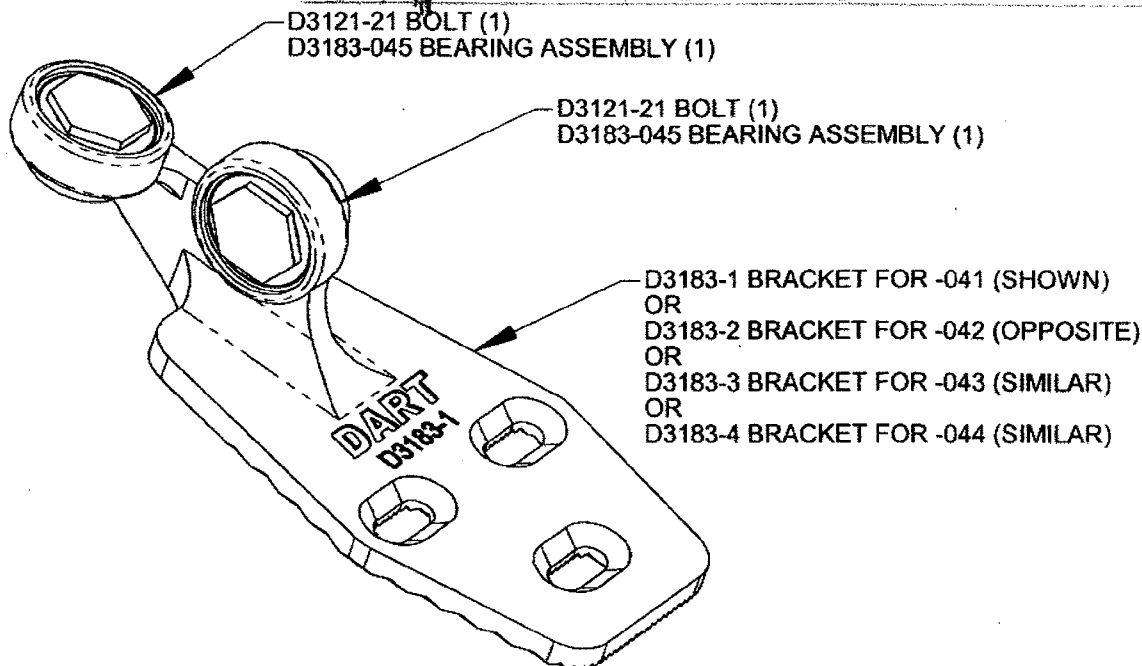
Measured by:	<i>MP</i>	Audited by:	<i>an</i>	Prototype Approval:	N/A
Date:	02/08/19	Date:	09/08/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue (P/O D3183-042)	KJ/JLM	<i>[Signature]</i>

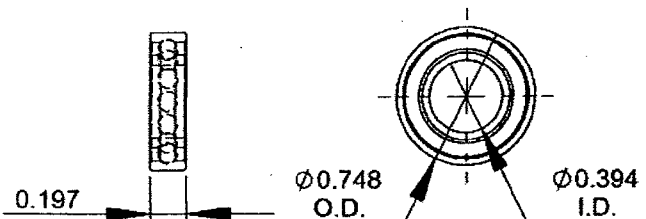


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04 03 01

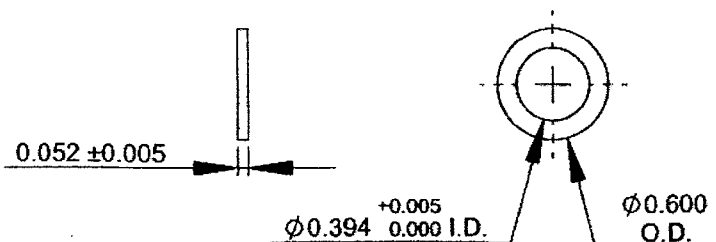


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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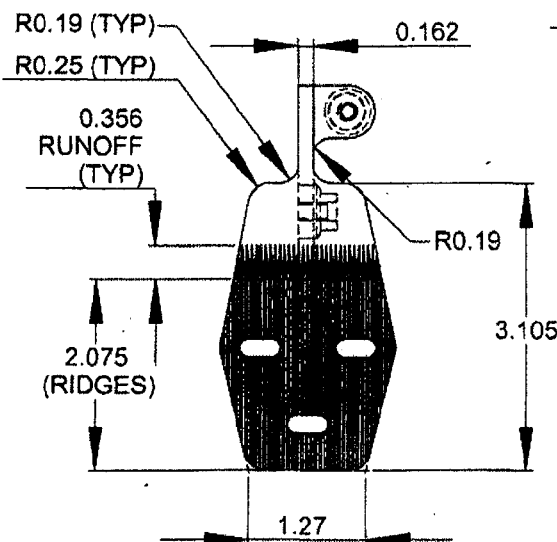
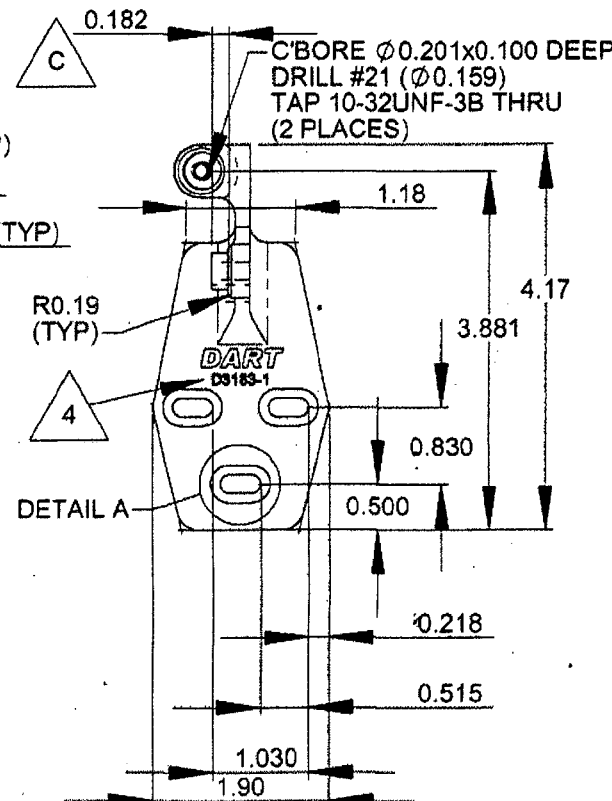
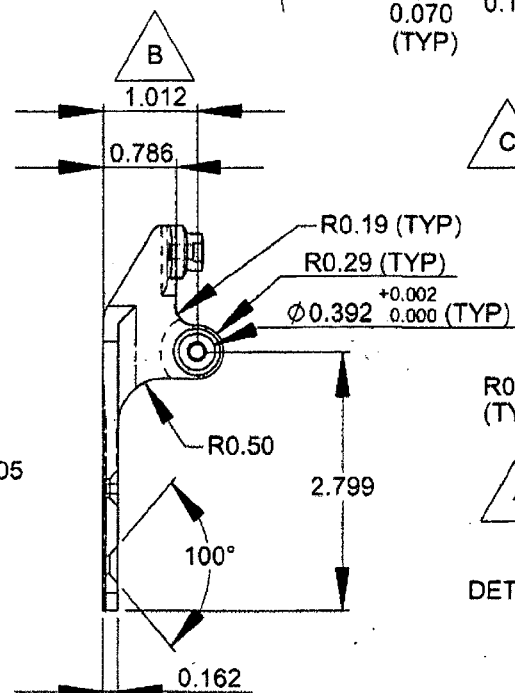
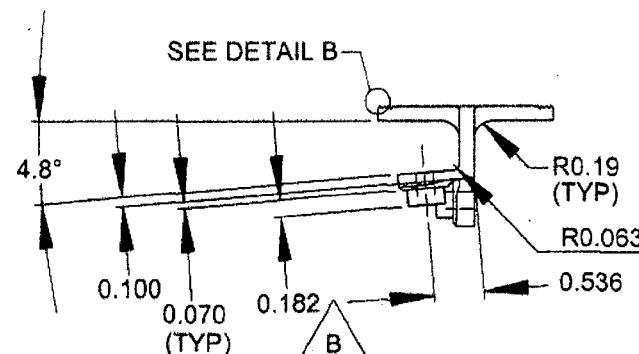
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DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 2 OF 4
	TITLE	SCALE
	BRACKET ASSEMBLY	1:2

RELEASED



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

50253

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QAGC
ISSUED

DESIGN	DRAWN BY		DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. C
		D3183		SHEET 3 OF 4
DATE	TITLE		SCALE	
04.02.17	BRACKET ASSEMBLY		1:2	



1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) ENGRAVE DART P/N & LOGO AS SHOWN

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

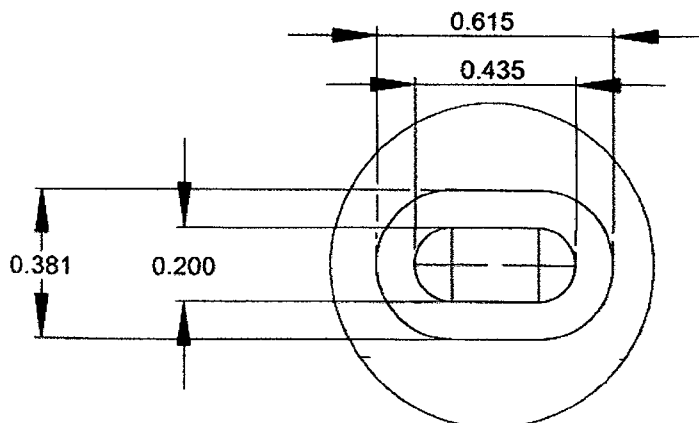
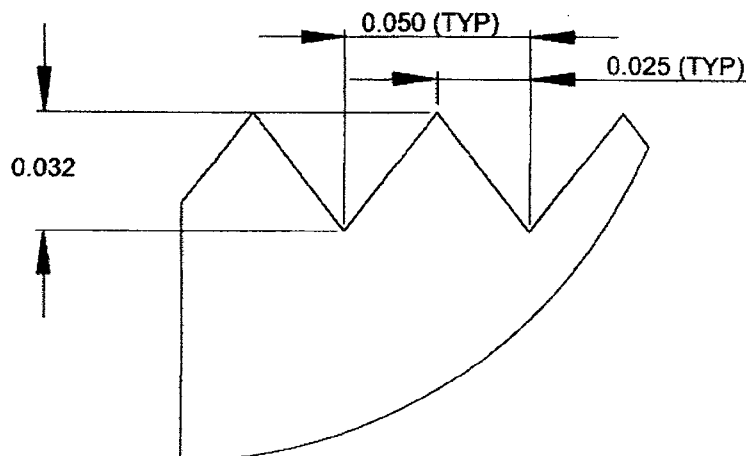
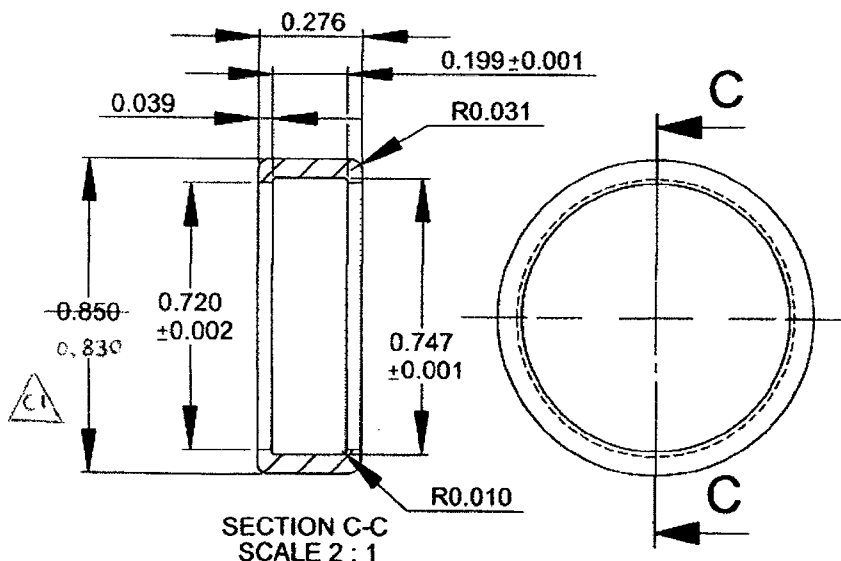
5) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A (2 : 1)***CS205***RELEASED**
04-03-01**DETAIL B (20 : 1)****D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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